

WP 08-PT.08  
Revision 6

# WIPP Centralized Procurement Program Plan

Cognizant Section: Packaging

Approved by: Todd Sellmer



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**LIST OF ACRONYMS AND ABBREVIATIONS**

CBFO	Carlsbad Field Office
C of C	Certificate of Conformance
CPC	Centralized Procurement Coordinator
CPP	Centralized Procurement Program
CPPP	Centralized Procurement Program Plan
DOE	U.S. Department of Energy
FO	Fabrication Oversight
IEWO	Inter-entity Work Order
QA	Quality Assurance
QAIP	Quality Assurance Inspection Plan
QAIS	Quality Assurance Inspection Services
QAPD	Quality Assurance Program Description
QSL	Qualified Suppliers List
TRU	Transuranic
WIPP	Waste Isolation Pilot Plant

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### 1.0 INTRODUCTION

#### 1.1 Purpose

The Centralized Procurement Program Plan (CPPP) identifies the elements required to provide a standardized, economical system of acquisition and distribution of common or critical transuranic (TRU) waste commodities (items) for the U.S. Department of Energy (DOE) Carlsbad Field Office (CBFO).

Overall, the CPPP describes and documents the process for procurement and acceptance of items manufactured for the Washington TRU Solutions LLC (WTS) Centralized Procurement Program (CPP). These actions establish inventory for TRU waste generator (user) sites.

#### 1.2 Scope

The CPP is designed to allow user sites to procure items manufactured to standardized WTS quality, procurement, and technical requirements. WTS is the design authority for all products in the program, with the exception of commercially available items such as drums and rigid drum liners. Different rules apply to the commercially available items relative to the procurement, fabrication, receipt inspection and return authorization, and are identified throughout Sections 4.9 and 4.10.

The CPP includes provisions for the WTS QA Fabrication Oversight (FO) Section of Assurance Programs. FO conducts and oversees quality-related functions to support the Waste Isolation Pilot Plant (WIPP). FO follows WTS procedure WP 13-QA3020, Fabrication Oversight. FO accomplishes activities consistent with the supplier's planned inspections, examinations, or tests. FO acts at intervals consistent with the importance and complexity of the commodity.

Packaging-related items subject to reprocessing that were previously manufactured under provisions of the WIPP design basis are classified as "excess material." Excess material requires acceptance via an approved WTS quality assurance inspection plan (QAIP). All packaging-related items eligible for reprocessing are acceptable for use after undergoing the process of a rework traveler and acceptance via an approved QAIP.

WTS issues subcontracts to meet the program objective. Subcontracts are binding agreements between the supplier and WTS for the manufacture of TRU waste items. Some of the terms and conditions within the subcontracts include:

- Scope of work
- Release Orders
- Funding
- Payment/Delivery
- Pricing

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| With subcontracts in place, WTS and user sites (working through WTS) can buy items at firm, fixed unit prices.

| **2.0 RESPONSIBILITIES**

**2.1 General**

WTS provides services to user sites as stated in WTS implementing procedures. Services provided by a CPP-integrated team of WTS staff personnel shall include, but not be limited to, the following:

- Performing procurement activities in accordance with WP 15-PC3609, Preparation of Purchase Requisitions.
- | • Performing subcontract technical representative and buyer duties.
- Evaluating all CPP suppliers for inclusion on the WTS Qualified Suppliers List (QSL).
- | • Preparing WTS commodity fabrication specifications and design drawings.
- Performing First Article and source inspections.
- Providing in-process procurement, quality assurance, accounting, and engineering support.
- | • Reviewing data package for each lot of commodities delivered.
- Verifying that manufacturing pedigree documentation (a data package) is given to user sites.
- Recommending user site receipt/inspection requirements.

| **2.2 Centralized Procurement Coordinator**

The Centralized Procurement Coordinator (CPC) performs the day-to-day tasks associated with the project. The CPC shall be responsible for the following:

- Preparing purchase requisitions to submit to suppliers following receipt of user site orders; identifying in purchase requisitions the applicable commodity fabrication specifications/design drawings, acceptance requirements, and customer requirements (quantity, delivery schedule, shipping methods, etc.).
- | • Supporting the competitive bid process by generating statements of work and technical evaluation criteria, estimating commodity demands and costs, and facilitating proposal technical evaluation teams.

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- Coordinating and monitoring technical activities of subcontracts, including delivery schedules; performing subcontract technical representative duties per the STR procedure, WP 15-PC-3608, Subcontract Technical Representative Responsibilities.
- Serving as the program point-of-contact.
- Verifying that applicable technical and quality requirements are incorporated into purchase requisitions and orders.
- Consulting with WTS Procurement on subcontract changes.
- Monitoring suppliers' compliance with subcontract requirements.
- Verifying that user site funding and flow-down requirements are available before shipping item(s) or placing an order.
- Processing supplier approval/variation requests (except for Commercially Available Items).
- Maintaining records to substantiate services rendered.
- Maintaining a file of all reports, correspondence, memoranda, and other pertinent documentation for each subcontract.
- Receiving, routing for review, maintaining, and transmitting final data packages (pedigree/final acceptance documentation).
- Processing user site nonconformances, when applicable, within five days of notification.
- Maintaining the CPP web page.
- Compiling and combining user site orders; establishing priorities for meeting the needs of multiple user sites.
- Providing commodity as-built drawings to user sites.
- Providing required documentation to Quality Assurance Inspection Services (QAIS) for item(s) received at WIPP.
- Inputting receivers into Integrated Financial Management System (IFMS) following delivery of approved commodities to user sites; approving supplier invoices for payment.
- Generating warehouse stored stock and shipping authorization documentation for items stored in inventory at WIPP and transmitting to Inventory Control for processing.

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- Verifying that supplier(s) are paid timely.
- Supporting source and First Article inspections.
- Obtaining projected commodity demands from user sites.
- Monitoring continuous program improvement.
- Authorizing return of defective commodities to vendor for warranty repair.

**2.3 Fabrication Oversight (FO)**

**Oversight Programs** shall be responsible for the following:

- Developing and executing QAIPs for related items following WP 13-QA3020, if applicable.
- Providing FO during the manufacturing and/or reacceptance process.
- Generating WTS Certificate of Conformance (C of C) specified in respective QAIPs, if applicable.
- Reviewing and approving purchase requisitions generated by the Centralized Procurement Coordinator.

**Assurance Programs** shall be responsible for the following:

- Reviewing and approving purchase requisitions generated by the Centralized Procurement Coordinator.
- Ensuring qualified suppliers are maintained on th QSL for CPP commodities

**2.4 User Sites**

WTS is a provider of Government services and can be qualified as a QSL vendor through each user site's QA program. User sites are responsible for conducting their own methods of acceptance (including receipt inspection) of items procured via this program.

**3.0 PROGRAM ELEMENTS**

**3.1 Methodology**

CPP activities shall be performed following implementing procedures that meet the requirements of WP 13-1, Washington TRU Solutions LLC Quality Assurance Program Description (QAPD).

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The CPP product line shall include common items that have one or more of these characteristics:

- | • Associated with the characterization, packaging, and handling of TRU waste,
- | • Critical, single-point failure items that could inordinately delay shipments,
- | • Significant level of quality and documentation required by safety analysis report,
- | • Recurring orders placed throughout a one-year period,
- | • Long-term need (multiple years),
- | • Large-volume usage.

| Applicable subcontracts, WTS implementing procedures, and related rules and regulations shall define activities provided by WTS. The subcontract establishes relationships between WTS, suppliers, and user sites. User sites are responsible for maintaining internal procedures for acceptance and/or receipt inspection(s) based on technical specifications and guidelines contained in this document.

| WTS shall maintain configuration of commodity fabrication specifications, design drawings, and QA inspection plans.

| Elements of a final data package are standardized and may be subject to change per customer request. Commodities including Commercially Available Items are drop shipped to the user sites. WTS will facilitate the transmittal of the final data package for each respective commodity to the user site. The approval/variation process is not used to transmit Commercially Available Item documentation.

**3.2 Recurring Procurement**

Once user sites identify a need for a commodity, they should contact the CPC to start the ordering process steps. Contact information is published on the CPP web page at <http://www.wipp.energy.gov/library/cpp/cpp.htm>.

User site orders shall include the following elements:

- | • Commodity description,
- | • Commodity quantities,
- | • Commodity manufacturing options, if applicable,
- | • Commodity identification requirements (e.g., markings), if applicable,
- | • Need date(s).



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The user site's financial obligation shall include the following:

- | • The sum of the extended unit price from the subcontract line item, plus the allocated transportation charge (e.g., freight, pallets),
- | • WTS QA oversight cost recovery fee (1.5%),
- | • The state gross receipts tax, if applicable,
- | • Any allocated tooling or other charges related to the order, as applicable.

| The user site(s) and WTS CPP Coordinator and Procurement shall negotiate delivery schedules on orders. Schedules are not binding until a release order(s) is accepted by the supplier and user site(s). WTS shall monitor the delivery schedule during the manufacturing process. WTS will advise user sites of issues it identifies, if any, during WTS's monitoring activities.

If the combined delivery requests surpass the capacity of a supplier or impacts existing delivery schedules, the CPC shall seek methods of relief. If relief cannot be obtained, the affected user sites, WTS, and the CBFO shall develop priorities and allocate stock.

During production, WTS shall provide in-process procurement, quality, and engineering support, including data package review. WTS shall provide a C of C showing that its procurement process applied to any particular purchase order or delivery complied with the QAPD.

Issues associated with elements of a user site order that are considered by WTS to be "above-and-beyond" a commodity design basis shall be handled at the contractual level only.

WTS shall review, and when appropriate, provisionally accept the data package for procured items. When WTS determines that the submitted data package is acceptable, WTS will authorize the supplier to ship item(s) (to include a copy of the data package submitted electronically) to the receiving site. User sites should perform a receiving inspection using site-specific procedures and applicable rules and regulations, and shall inspect commercially available items in accordance with the inspection criteria provided in Sections 4.9.1.4 and 4.10, as applicable.

| Shipments from suppliers shall be made to ensure that the most cost-effective method of shipping is used by suppliers.

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**3.3 Certificate of Conformance**

Initiation of the C of C is for those commodities that WTS maintains design authority for and is initiated according to the provisions of 13-QA3020.

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**NOTE**

The size of the data package may range from a few pages consisting of a supplier's C of C and nonconformance reports to documentation including, but not limited to, inspection reports, test reports (including non-destructive examination reports), manufacturing and inspection travelers, checklists.

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**3.4 Product Line Additions**

The CPC shall survey the sites to project the needs of the complex in terms of quantities, deliveries, and unique requirements.

If a commodity fabrication specification exists, WTS shall review the specification and update it, if needed, before requesting supplier proposals.

If a commodity specification does not exist, WTS shall compile a draft specification, in coordination with WTS QA, and route it to the user sites for endorsement. Each specification shall include quality and technical requirements and deliverables.

After compiling each site's specific needs and reconciling the resulting differences, conflicts, or concerns, the CPC shall request supplier proposals per WTS procurement procedures. Selection of a supplier shall include, but not be limited to, an evaluation of the supplier's QA program and competency using the requirements of the WTS QA program. WTS shall not place purchase orders until a supplier is placed on the WTS QSL and meets the prerequisites of this plan.

**3.3 Excess Material**

Excess material is packaging-related items previously manufactured under provisions of the WIPP design basis and returned to CPP via a SF-122 transfer per WP 15-PM3509, Utilization and Disposal of Excess/Surplus Government Personal Property. Excess material applies only to those commodities that WTS maintains design authority for, and is not applicable to Commercially Available Items. Contact WTS Property Management for guidance. This material is subject to reprocessing. If reprocessed, they require acceptance via an approved WTS QAIP.

Items shall be identified as acceptable for use only after undergoing the process of a supplier rework traveler, if required, and acceptance via a QAIP. The supplier shall modify final data package records accordingly. Only acceptable material shall be stored in inventory and made available to user sites.

Excess material is available to user sites on a no-cost basis, excluding freight costs.

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**3.4 Price-Anderson Amendments Act**

The Price-Anderson Amendments Act rules are generally applicable to contractors, subcontractors, and other suppliers who are responsible for performing activities or supplying services or products that are subject to DOE nuclear safety requirements.

**3.5 Finance and Payment**

| User sites shall either use an Inter-entity Work Order (IEWO), Memorandum Purchase Order (MPO) or other approved financial document to provide source funding for commodity procurement before orders are placed on their behalf.

For new items or new suppliers, certain nonrecurring costs for tooling apply. WTS shall encourage the supplier to amortize such costs on a per unit basis over the first year's production. However, when separate funding is necessary, the CBFO and WTS may choose to fund the tooling up front. In this case, the CBFO expects to recoup nonrecurring tooling costs by adding the unitized amortization amount to the supplier's price to arrive at the price user sites must pay. The DOE retains title for all tooling acquired through the subcontract.

Following receipt of item(s) by the ordering site, WTS Accounting shall make payment to the supplier after the CPC formally inputs receivers into WTS financial system.

| If source funding involves direct invoicing of user site, Accounting shall invoice the user site and verify that payment is received. If source funding is associated with an IEWO, Accounting shall invoice the user site via the approved process.

**3.6 Performance Measures**

To achieve continuous program improvement, the following areas shall be monitored on a continuous basis:

- Customer Satisfaction - a function of participant satisfaction with the program
- Delivery Schedule - a function of how well delivery schedules are being met
- Product Quality - a function of manufacturing quality and user site acceptance

**3.7 Change Control**

| The associated subcontracts establish provisions for subcontract and release order amendments.

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**3.8 Contingency Plan**

WTS shall create release order contingency measures in each subcontract. Within the terms and conditions of each subcontract, established performance metrics shall identify early warning of schedule delay, contract termination, and quality discrepancies. Also, identified corrective action measures shall exist should performance metrics be needed.

**3.9 Return Authorization**

Defective commodities may be returned to the vendor for warranty repair only after WTS authorizes the return. Return Authorization is applicable only to those commodities that WTS maintains design authority for, and is not applicable to Commercially Available Items. Provisions of return authorization include the following:

- WTS (design authority) validates site nonconformance/deficiency condition as a repair condition.
- Period from delivery to identification of defect should be minimized to the extent possible to facilitate correcting the defect in a timely manner.
- Objective evidence that the commodity was not damaged by user site.
- A commodity receipt inspection was performed and documented upon receipt at the user site.

Nonconformance/deficiency reports shall be submitted by the user site to WTS. WTS will submit the Nonconformance/deficiency report to the Supplier. The Supplier shall formally submit to WTS in accordance with WP 15-PC3041, Approval/Variation Request Processing.

CPP will authorize the return of commodities for warranty work, providing the warranty period has not expired. If the warranty period has expired, the user site has the option of returning the items to the vendor for repair at their own expense through the CPP.

**3.10 Commodity Storage**

Unless prior arrangements have been made with the vendor, the number of stored user site commodities shall not exceed the equivalent of two weeks of production. User sites are subject to storage fees if an excessive number of items are not allowed to be delivered. Commodity Storage applies only to those commodities that WTS maintains design authority for, and is not applicable to Commercially Available Items.

**4.0 CURRENT PRODUCTS**

The CPP currently provides the following items. The list also identifies the respective fabrication specification, design drawings, and QAIPs. Centralized Procurement may expand this list as needed.

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**4.1 Standard Waste Box (SWB)**

- WTS Drawings 165-F-001-W Series, Standard Waste Box Assembly
- WTS Specification E-I-343, Specification for Fabrication of the Standard Waste Box
- WTS procedure WP 13-QA.19, Quality Assurance Inspection Plan for Standard Waste Box Inventory

**4.2 Ten-Drum Overpack (TDOP)**

- WTS Drawings 165-F-010-W Series, TRUPACT-II Ten Drum Overpack\_Assembly
- WTS Specification E-I-430, Specification for Fabrication of the Ten Drum Overpack
- WTS procedure WP 13-QA.20, Quality Assurance Inspection Plan for Ten-Drum Overpack Inventory

**4.3 Adjustable Center-of-Gravity Lift Fixture (ACGLF)**

- WTS Drawings
  - 412-L-078-W Series, ACGLF Top Assembly
  - 412-L-079-W Series, ACGLF Frame Weldment
  - 412-L-080-W Series, ACGLF Upper Structure Turntable Weldment
  - 412-L-081-W Series, ACGLF Counterweight Fabrication and Assembly
  - 412-L-082-W Series, ACGLF Leg Weldment and Miscellaneous Details
  - 412-L-083-W, ACGLF Wiring Diagram
  - 412-L-084-W Series, ACGLF Control Console Parts List and Notes
  - 412-L-085-W Series, ACGLF AC and DC Junction Boxes and Actuators
  - 412-L-086-W, ACGLF Electrical Installation
- WTS Specification – E-I-441, Specification for Fabrication of the Adjustable Center-of-Gravity Lift Fixture Adapter
- WTS procedure WP 13-QA.11, Quality Assurance Inspection Plan for the Adjustable Center of Gravity Lift Fixture (ACGLF) Inventory

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**4.4 Standard Waste Box Lift Fixture Adapter**

- | • WTS Drawing – 412-N-003-W, TRUPACT-II Standard Waste Box Lift Fixture Adapter
- | • WTS Specification – E-I-336, Specification for Fabrication of the Standard Waste Box Lift Fixture Adapter
- | • WTS procedure WP 13-QA.10, Quality Assurance Inspection Plan for the Standard Waste Box Lift Fixture Adaptor Inventory

**4.5 Ten-Drum Overpack Lift Fixture Adapter**

- | • WTS Drawing – 41-L-004-W, TDOP Lift Fixture Adapter
- | • WTS Specification – E-I-422, Specification for Fabrication of the Ten Drum Overpack Lift Fixture Adapter
- | • WTS procedure WP 13-QA.12, Quality Assurance Inspection Plan for the Ten-Drum Overpack Lift Fixture Adaptor Inventory

**4.6 Standard Large Box 2 (SLB2)**

- | • WTS Drawing – 165-F-016-W Series, Standard Large Box 2 Assembly (SLB2) Top Loading
- | • WTS Drawing – 165-F-017-W Series, Standard Large Box 2 Assembly (SLB2) Bottom Loading
- | • WTS Specification – E-I-463, Specification for Fabrication of the Standard Large Box 2
- | • WTS procedure WP 13-QA.30, Quality Assurance Inspection Plan for the SLB2, Top Loading

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**4.7 Removable Lid Canister (RLC)**

- WTS Drawing 165-F-007-W Series, RH-TRU 72-B Cask Removable Lid Canister Assembly
- WTS Drawing 165-F-025-W Series, RH-TRU 72-B Removable Lid Canister Sealed Spring Plunger
- WTS Specification – E-I-446, Specification for Fabrication of the RH-TRU 72-B Cask Removable Lid Canister Assembly
- WTS procedure WP 13-QA.34, Quality Assurance Inspection Plan for the RH-TRU Removable Lid Canister

**4.8 Shielded Container Assembly (SCA)**

- WTS Drawing 165-F-026-W Series, Shielded Container Assembly
- WTS Specification – E-I-478, Specification for Fabrication of the Shielded Container Assembly
- WTS procedure WP 13-QA.40, Quality Assurance Inspection Plan for the Shielded Container Assembly

**4.9 Pipe Overpack**

- WTS Drawing 165-F-027, 6 In. Standard Pipe Overpack
- WTS Drawing 165-F-028, 6 In. Pipe Component
- WTS Drawing 165-F-029, 6 In. Pipe Component Dunnage
- WTS Drawing 165-F-030, S100 Pipe Overpack
- WTS Drawing 165-F-031, 12 In. Standard Pipe Overpack
- WTS Drawing 165-F-032, 12 In. Pipe Component
- WTS Drawing 165-F-033, 12 In. Pipe Component Dunnage
- WTS Drawing 165-F-034, S200-A Pipe Overpack
- WTS Drawing 165-F-035, S200-B Pipe Overpack
- WTS Drawing 165-F-036, S300 Pipe Overpack
- WTS Specification – E-I-479, Specification for fabrication of the Pipe Overpack (Standard, S100, S200 and S300)

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- WTS procedure WP 13-QA.42, Quality Assurance Inspection Plan for the Pipe Overpack (Standard, S100, S200 and S300)

#### **4.10 Slip Sheets and Reinforcing Plates**

To support TRU waste packaging at designated sites, CPP will procure TRUPACT-II, 7-Pack 55-Gallon Drum slip sheets and reinforcing plates in accordance with WTS Drawing 412-F-013-W through the authorized manufacturer. Slip sheets and reinforcing plates shall be shipped directly from the manufacturer, and drop shipped to the user sites. WTS will facilitate the transmittal of the applicable documentation to the user site. Receipt inspection for the slip sheets and reinforcing plates shall be in accordance with the criteria provided in the purchase order.

#### **4.11 Commercially Available Items**

CPP will procure select commercially available items as part of the support function for TRU waste packaging at designated Sites. The commercial items are limited to the commodities listed in this section and must be procured from a supplier on the Washington TRU Solutions (WTS) Qualified Supplier's List (QSL). Any exceptions to the use of a QSL supplier will require Commercial Grade Item Dedication (CGID) in accordance with WP 09-CN3040. If the item does not meet the criteria for a Commercially Available Item, a WTS Qualified Supplier must be used, or controlled by working under the WTS QAPD.

##### **4.11.1 DOT 7A Type A Drums**

The DOT 7A Type A drums offered are available in five different capacities. The drums shall be marked in accordance with 49 CFR 178.503, *Marking of Packagings*, fabricated in accordance with 49 CFR 178.504 *Standards for Steel Drums*, are designed and tested in accordance with the applicable requirements of 49 CFR 173.465 *Type A Packaging Tests*. The drums shall meet the requirements for shipping transuranic waste to WIPP. The drums shall be UN rated for solids, but need not meet the UN rating for liquids.

- 16-Gallon - The 16-gallon drum is equipped with a lever-lock closure ring and gasketed lid, and meets DOT 7A Type A packaging requirements when assembled in accordance with the manufacturer's closure instructions.
- 30-Gallon - The 30-gallon drum is equipped with an internal lever-lock closure ring and gasketed lid, and meets DOT 7A Type A packaging requirements when assembled in accordance with the manufacturer's closure instructions.
- 55-Gallon - The 55-gallon drum is equipped with a bolt closure ring and gasketed lid, and meets DOT 7A Type A packaging requirements when assembled in accordance with the manufacturer's closure instructions.



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- 85-Gallon - The 85-gallon drum is equipped with a bolt closure ring and gasketed lid, and meets DOT 7A Type A packaging requirements when assembled in accordance with the manufacturer's closure instructions.
- 100-gallon - The 100-gallon drum is equipped with a bolt closure ring and gasketed lid, and meets DOT 7A Type A packaging requirements when assembled in accordance with the manufacturer's closure instructions.

4.11.2 Drums shall be procured by WTS through the drum manufacturer, or an authorized distributor, as applicable. Drums shall be shipped directly from the manufacturer, and drop shipped to the user sites. WTS will facilitate the transmittal of the final data package for each respective commodity to the user site. The approval/variation process is not used to transmit Commercially Available Item documentation.

4.11.3 Drum fabrication is performed in accordance with the drum manufacturer's drawings, specifications and quality assurance program. WTS is not the design authority for these items, and therefore does not hold the responsibility for overseeing their fabrication.

4.11.4 Drums that are delivered to user sites where a receiving and inspection program has been established through the Central Characterization Project (CCP) will continue to be inspected in accordance with the established program.

4.11.5 Drums that are delivered to user sites where a receiving and inspection program has NOT been established through the Central Characterization Project (CCP) shall be inspected in accordance with the following requirements:

- Receipt inspection shall be performed by personnel qualified to perform the receipt inspection.
- Statistical sampling shall be used to verify the acceptability of a group of drums, and shall be based on ANSI/ASQC Z1.4, *Sampling Procedures and Tables for Inspection by Attributes*.
- Inspection of drums for receipt shall be performed by completing Attachment 1, Receipt Inspection Checklist for Drums, and forwarding to WTS Procurement to verify acceptance.
- Once the drums are accepted, the user site shall assume ownership of the drums.

**Return Policy**

If any drums or rigid drum liners are found to be nonconforming, the user site shall notify WTS Procurement to initiate replacement of the non-conforming items in accordance with the Supplier or subcontracted designee's standard return policy.

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#### **4.12 Rigid Drum Liners**

Rigid drum liners are constructed of high-density polyethylene, 90-Mil, and are available for 55-gallon drums only.

Rigid drum liner fabrication is performed in accordance with the manufacturer's drawings, specifications and quality assurance program, as applicable. WTS is not the design authority for these items, and therefore does not hold the responsibility for overseeing their fabrication.

Procurement of rigid drum liners shall be performed by the drum manufacturer, or an authorized distributor, as applicable. Rigid drum liners shall be inspected by the drum manufacturer prior to installing them in the drums.

Receipt inspection of rigid drum liners at the at the drum manufacturing facility shall be performed by personnel qualified to perform the receipt inspection. Statistical sampling shall be used to verify the acceptability of a group of rigid drum liners, shall be based on ANSI/ASQZ1.4, *Sampling Procedures and Tables for Inspection by Attributes*. Inspection of rigid drum liners for receipt shall be in accordance with the following criteria:

- No damage occurred during shipment
- The item received is the item ordered
- Documentation, as applicable to the rigid drum liners was received and is acceptable

#### **4.13 Spare Parts**

Spare parts for all commodities such as TDOP gaskets, lid bolts, drum locking rings shall be produced through the CCP Program.

#### **5.0 REFERENCES**

- ANSI/ASQZ1.4, *Sampling Procedures and Tables for Inspection by Attributes*
- Price-Anderson Amendments Act
- WP 13-1, Washington TRU Solutions LLC Quality Assurance Program Description
- WP 13-QA.10, Quality Assurance Inspection Plan for the Standard Waste Box Lift Fixture Adaptor Inventory
- WP 13-QA.11, Quality Assurance Inspection Plan for the Adjustable Center of Gravity Lift Fixture (ACGLF) Inventory

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- WP 13-QA.12, Quality Assurance Inspection Plan for the Ten-Drum Overpack Lift Fixture Adaptor Inventory
- WP 13-QA.19, Quality Assurance Inspection Plan for Standard Waste Box Inventory
- WP 13-QA.20, Quality Assurance Inspection Plan for Ten-Drum Overpack Inventory
- WP 13-QA.30, Quality Assurance Inspection Plan for the Standard Large Box 2 (SLB2), Top Loading
- WP 13-QA.34, Quality Assurance Inspection Plan for the RH-TRU Removable Lid Canister
- | • WP 13-QA.40, Quality Assurance Inspection Plan for the Shielded Container Assembly
- WP 13-QA3020, Fabrication Oversight
- WP 15-PC3041, Approval/Variation Request Processing
- | • WP 15-PC-3608, Subcontract Technical Representative Responsibilities
- WP 15-PC3609, Preparation of Purchase Requisitions
- WP 15-PM3509, Utilization and Disposal of Excess/Surplus Government Personal Property
- | • WP 13-QA.42, Quality Assurance Inspection Plan for the Pipe Overpack (Standard, S100, S200 and S300)
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**WIPP Centralized Procurement Program Plan  
WP 08-PT.08, Rev. 6**

**Attachment 1 - Receipt Inspection Checklist for Drums**

<b>Receipt Inspection Checklist for Drums</b>			
<p>The receiver shall inspect drums in accordance with the inspection criteria below and complete this attachment. Conformance shall be indicated in the "Yes, No or N/A" column by a Y, N or N/A. Conformance is not limited to the inspection criteria on this attachment. Nonconformances outside the inspection criteria shall be described in the comments section.</p>			
	<u>Conformance</u>	<u>Yes, No* or N/A</u>	<u>Inspection Criteria</u>
<u>1</u>	Documentation		Verify all required documentation received and acceptable.
<u>2</u>	C of C		Verify C of C (EA15PC3609-3-0) is provided and properly completed.
<u>3</u>	Markings		Verify upper third of drum body is stenciled with the WTS PO number, Supplier Lot number, and DOT 7A Type A. Lettering shall be black with 1/2" high characters.
			Verify each drum bottom is marked in accordance with 49 CFR 178.503 with UN designations applicable to solids, at a minimum, and the bottom of each drum embossed with the UN number(s) in 1/2" characters.
<u>4</u>	Closure Instructions		Verify drum closure instructions are included with each shipment of drums.
<u>5</u>	Paint		Verify drum, lid and locking ring are painted white as specified.
<u>6</u>	Locking Rings		Verify bolted locking rings close tightly; not loose around drum lid.
<u>7</u>	Drum surfaces		Verify drums are clean, and free of corrosion, pinholes, broken or cracked welds, dents, scrapes or scratches that may reduce the wall thickness or impact the structural integrity or prevent the top surfaces from being parallel.
<u>8</u>	Capacity		Verify drum is the capacity specified.
<u>9</u>	Dimensions		Verify drums meet dimensions/tolerances .
<u>10</u>	Gaskets		Verify gaskets are securely glued into the drum lids.
<u>11</u>	Rigid drum liner		Verify rigid drum liners are installed (55-gallon drums only), as applicable .
<u>12</u>	Rust Inhibitor		Verify drum interiors are treated with rust inhibitor.
			<p>* Provide a brief description for each "No" indication in the comments section below, and document nonconformances in accordance with user site procedures. Forward completed attachment to WTS in accordance with step 4.9.1.5.</p>

PO Number \_\_\_\_\_

Total Units Received \_\_\_\_\_

Sample Size \_\_\_\_\_ (Based on ANSI/ASQC Z1.4)

Inspector Signature/Date \_\_\_\_\_

Comments: \_\_\_\_\_  
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